



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5460-1
Job Sheet 178274



Part No: D5460-1

Job Qty: 50 ea

Part Name: Angle Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/29/18

Job Tracking No:

Due Date: 6/29/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B SHEET 1 IPP REV: A NEW ISSUE 16/09/15 JFS VERIFIED BY: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	50 Ea	6/29/18	6/29/18	0.00	0.00	Start Up Machining-4		
100	Bandsaw	50 pcs	6/29/18	6/29/18	0.00	2.50	Bandsaw1		DAS
110	CNC Vertical Machining	50 pcs	6/29/18	6/29/18	0.12	6.25	HAAS1-1		54
120	QC	50 pcs	6/29/18	6/29/18	0.00	0.00	QC2 Machining-4		9-89
130	QC	50 pcs	6/29/18	6/29/18	0.00	0.00	QC8 Machining-4		
135	HandFinish	50 pcs	6/29/18	6/29/18	0.00	0.53	HandFinish1		
140	QC	50 pcs	6/29/18	6/29/18	0.00	0.00	QC7-5		
150	Packaging	50 pcs	6/29/18	6/29/18	0.00	0.00	Packaging3-2		
190	QC21-SA	50 Ea	6/29/18	6/29/18	0.00	0.00	QC21		

Part Op 100 - Cut Blank 3.125" long

Descriptions: 110 - Mill as per Dwg & Folio FB498

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
647.1910E	Clip	13 ft (.26 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	647.1910E	13	108	0

Part Specifications

Specifications could not be found.



WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____
QA Closed: _____ Date: _____

Work Order update only

DISPOSITION		AGAINST DEPARTMENT/PROCESS																																																																																																																									
Work Order: _____	Rework ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	MRB (QS042) Approval																																																																																																																						
Part No. _____	Scrap ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																																																																																																							
NCR No. _____	Heat-treat ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																																																																																																							
Date: _____			Supplier ☐																																																																																																																								
Container No: S082580 Part: D5460 - 1 Job No: 178274 Serial No/Batch: S082580 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Date: 06/20/18																																																																																																																											
Root <table border="1"><tr><td>Environment</td><td>Design</td><td>Doc/Data</td><td>Equip/Tooling</td><td>Handling/Pre</td><td>Material</td><td>Internal Transport</td><td>Tribal Knowledge</td><td>LOA</td><td>Substation</td><td>Past Expiry Date</td><td>Misidentified</td></tr><tr><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td></tr></table> <table border="1"><tr><td>Offset/Setup</td><td>Supplier</td><td>Training</td><td>Use for Testing</td><td>Poor Information</td><td>Rushing</td><td>Product Improvement</td><td>Process Improvement</td><td>Manufacturing Process</td><td>Past Due</td></tr><tr><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td></tr></table> <table border="1"><tr><td>Centre Not Concentric</td><td>Cracks</td><td>Crimp/Kink/Ripple/Wave</td><td>Cuffs</td><td>Crushing</td><td>Heat Treat</td><td>Wave/Twist in Tube</td><td>Marks/Chatter</td><td>OTHER :</td></tr><tr><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td></tr></table> <table border="1"><tr><td>BOM/Route</td><td>Broken/Damage/Defect</td><td>Inspection Incomplete/Unqualified</td><td>Contamination</td><td>Countersink</td><td>Cut Too Short</td><td>Instructions Incomplete/Unclear</td><td>Drill Holes</td></tr><tr><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td></tr></table> <table border="1"><tr><td>Power Loss/Surge</td><td>Folio/Program</td><td>Grain</td><td>Weld</td><td>Wrong Stock Pulled</td><td>Out of Sequence</td><td>Off-set</td><td>Mislabeled</td><td>Fit/Function</td><td>Misaligned/off center</td></tr><tr><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td></tr></table> <table border="1"><tr><td>Positioned Wrong</td><td>Outside Dimensions</td><td>Over/Under tolerance</td><td>Part Incorrect</td><td>Part Lost/Missing</td><td>Part Moved</td><td>Drawing</td><td>Finish</td><td>Misread</td><td>Turning Sequence</td></tr><tr><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td></tr></table>						Environment	Design	Doc/Data	Equip/Tooling	Handling/Pre	Material	Internal Transport	Tribal Knowledge	LOA	Substation	Past Expiry Date	Misidentified													Offset/Setup	Supplier	Training	Use for Testing	Poor Information	Rushing	Product Improvement	Process Improvement	Manufacturing Process	Past Due											Centre Not Concentric	Cracks	Crimp/Kink/Ripple/Wave	Cuffs	Crushing	Heat Treat	Wave/Twist in Tube	Marks/Chatter	OTHER :										BOM/Route	Broken/Damage/Defect	Inspection Incomplete/Unqualified	Contamination	Countersink	Cut Too Short	Instructions Incomplete/Unclear	Drill Holes									Power Loss/Surge	Folio/Program	Grain	Weld	Wrong Stock Pulled	Out of Sequence	Off-set	Mislabeled	Fit/Function	Misaligned/off center											Positioned Wrong	Outside Dimensions	Over/Under tolerance	Part Incorrect	Part Lost/Missing	Part Moved	Drawing	Finish	Misread	Turning Sequence										
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Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																																																																																											

DQA: _____ Date: _____



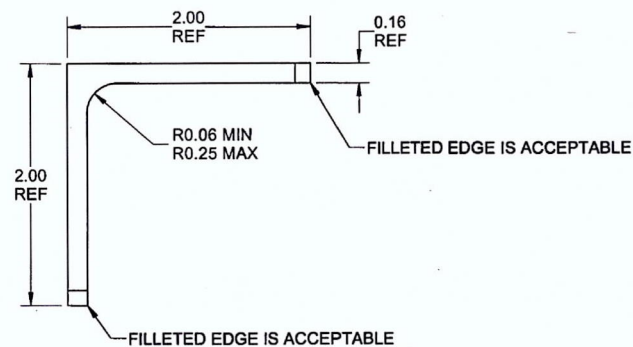
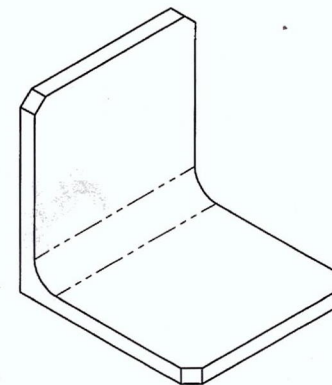
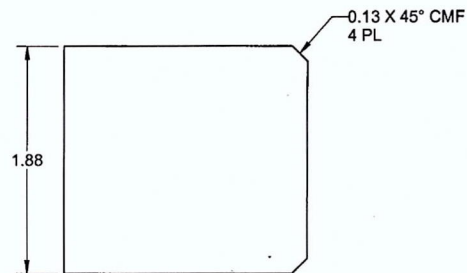
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

D 139-1012-011



D5460-1 ANGLE BRACKET

NOTES:

- 1) MATERIAL: 7075-T6/T6510/T6511/T62 ALUMINUM ANGLE, 2.00 X 2.00 X 0.16 THK
PER AMS-QQ-A-200/11
REF DART SPEC M7075T6A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 0.12 lbs

RELEASED
2017-02-28
ECN 17-530

APPROVED

B	SHEET 1: MATERIAL WAS 6061-T6 0.13 THK, WEIGHT UPDATED. REASON: MATERIAL AVAILABILITY. SHT 3 & -5 DELETED REASON: CUSTOMER FEEDBACK.		AJS	16.12.21
A	NEW ISSUE		AJS	16.09.14
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED	JH	DRAWING NO.	REV. B	
MFG. APPR.	DD	D5460	SHEET 1 OF 2	
APPROVED	WM	TITLE	SCALE	
DE APPR.	DS	HOOK SUSPENSION COMPONENTS	NTS	
DATE	16.12.21		COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

